



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE117-68021W13-3
Job Sheet 203755



16 pcs only

Part No: RBE117-68021W13-3 **Job Qty:** 4 pcs
Part Name: Impact Weight

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 11/27/19 **Job Tracking No:**
Due Date: 1/17/20 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**
Note: DWG RBE117-68021W13 Rev.1 IPP Rev. A 19.11.20 New issue DP Verify DD
Ship Via:

Bill of Materials

DAS
45 2019-12-11
9-80

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	NEX 2500SY - 1	4 pcs		1/17/20	1.00	5.33	NEX 2500SY - 1		<i>SL 12-14-19</i>
110	QC 2	4 pcs		1/17/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		<i>SL</i>
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
115	Conventional Mill - 1 - B4B	4 pcs	1/17/20	0.25 1.00	Conventional Mill - 1 - B4B	N 10/12/20
					Conventional Mill - 2 - B4B	
120	QC 2	4 pcs	1/17/20	0.00 0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	N 11/12/20
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
125	QC 8	4 pcs	1/17/20	0.00 0.00	QC 8 - 12	N 20/01/04
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	

Plex 11/27/19 8:42 AM Dart.lajeunesse.marie

			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
130	Outsource - 13 - Zinc Plating	4 pcs	1/17/20	
			GRO002-VC	<i>2020-01-08</i>
140	Packaging 2-1 - Receive - B4B	4 pcs	1/17/20	0.00 0.00
			Packaging 2 - 1 - B4B	
			Packaging 2 - 2 - B4B	
			Packaging 2 - 3 - B4B	
			Packaging 2 - 5 - B4B	<i>JAN 15 2020</i>
			Packaging 2 - 4 - B4B	
			Packaging 2 - 6 - B4B	
			Packaging 2 - 7 - B4B	
			Packaging 2 - 8 - B4B	
			Packaging 2 - 9 - B4B	
			Packaging 2 - 10 - B4B	
			Packaging 2 - 11 - B4B	
			Packaging 2 - 12 - B4B	
			Packaging 2 - 13 - B4B	
			Packaging 2 - 14 - B4B	
			Packaging 2 - 15 - B4B	
			Packaging 2 - 16 - B4B	
			Packaging 2 - 17 - B4B	
			Packaging 2 - 18 - B4B	
			Packaging 2 - 19 - B4B	
			Packaging 2 - 20 - B4B	
			Packaging 2 - 21 - B4B	
			Packaging 2 - 22 - B4B	
			Packaging 2 - 23 - B4B	
			Packaging 2 - 24 - B4B	
			Packaging 2 - 25 - B4B	
			Packaging 2 - 26 - B4B	
150	QC 6	4 pcs	1/17/20	0.00 0.00
			QC 6 - 9	
			QC 6 - 68	<i>JAN 15 2020</i>
			QC 6 - 61	<i>DAS 68</i>
			QC 6 - 40	<i>9-89</i>
			QC 6 - 81	
160	Packaging 3-1 - Stock - B4B	7x pcs	1/17/20	0.00 0.00
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
170 QC 21 - SA	4	1/17/20	0.00 0.00	QC 21 - SA - 21	JAN 15 2020

pcs

DAS
21

GA133

Part Op 100 - 1-Machine as per folio FD 111 FOLIO REV: DWG REV: 1 2-Debur 3-Apply

Descriptions: LPS-3 to ALL steel parts

110 - QC2- Inspect parts off machine FAI/FAIB

115 - 1-Machine as per DWG. 2-Debur

120 - (QC2- Inspect parts off machine FAI/FAIB)

125 - QC8- Inspect parts - second check

130 - -Issue P/O : 45317 -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required

140 - (Receive & Inspect for Damage & Mat'l Certs) Certificate of Conformity is required

150 - QC6- All purchased or subcontracted products

160 - Identify as per dwg & Stock Location:

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R2.000	AISI 4140 Quenched & Tempered Steel Round Bar 2.000" Dia.	.6880 ft (.172 ea)	100-NEX 2500SY -	

SL
DAS
15
9-89

SL69097

2014-12-4

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-NEX 2500SY - 1	MT-4140QT-R2.000	1	16	0

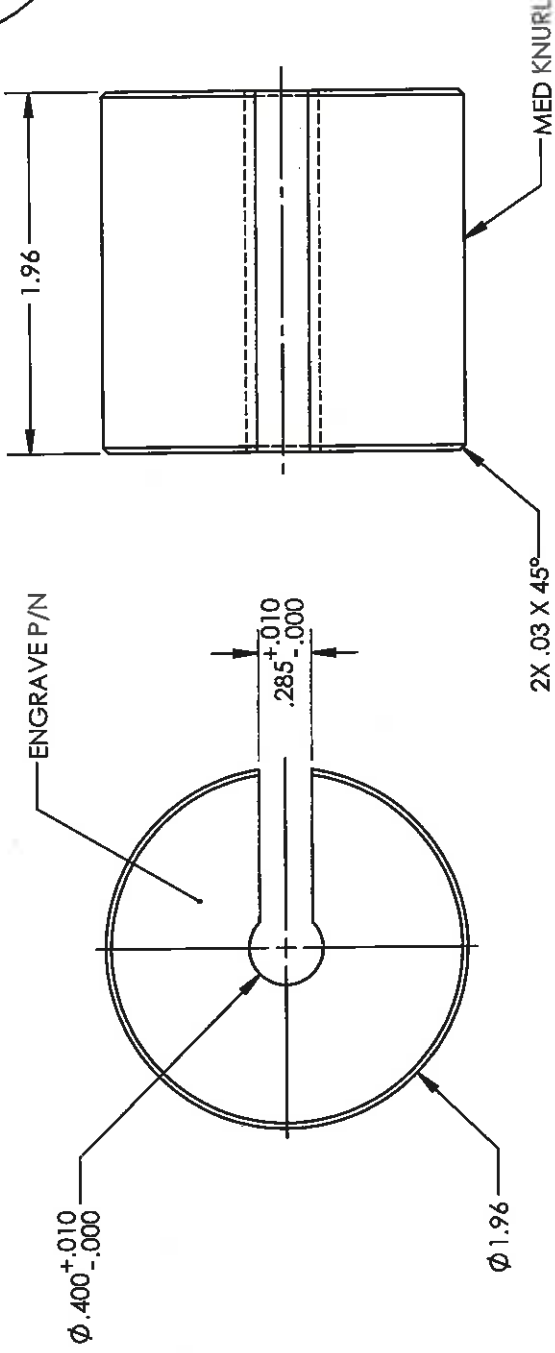
SL
DAS
15
9-89

Part Specifications

Specifications could not be found.

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REVISIONS			
REV	ECR	DATE	INITIAL APPROVED



EXTRACTOR

TITLE	RBE117-68021W13-3		
DWG NO.	REV 1		
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED		
HEAT TREAT RC 28-34	DIMENSIONS ARE IN INCHES		
FINISH ZINC PLATE	.XXX ± .006 FRACTIONS ± 1/8		
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 1°		
DRAWN BY: DUERFELDT	.X ± .1 SURFACES ± 125		
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES		
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY		
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER		
APPROVED: GILBERT	ASME Y14.6M-2009		
SCALE 1:1	USED ON MODEL		
DATE 8/25/2016	H145		
SHEET 3 OF 4			

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 203755 M/S
19-11-27

(-3)

IMPACT WEIGHT

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QS042)					
Description Work Order Deviation		Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐							
						Completed By			
						Lead hand / Supervisor			
						QC / QA Coordinator			

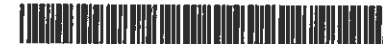


Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045517



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045517

PO Date: 1/8/20

Due Date: 1/16/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

EMAILED
2020-01-10

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	203528	RBE105-42121W6-1	RBE105-42121W6 Rev 1	Staking Tool Assembly -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed X7	-	1/16/20	7 pcs	0 pcs	7 pcs	\$7.1428/pcs	\$50.00
2	203755	RBE117-68021W13-3	RBE117-68021W13 Rev 1	Impact Weight -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed X7	-	1/16/20	7 pcs	0 pcs	7 pcs	\$7.1428/pcs	\$50.00
Grand Total:												\$100.00

Guérin

	Dart Aerospace Ltd. 1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada Tel (613) 632-5200	PURCHASE ORDER POHB045517 
Order Notes Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.		

Plex 1/10/20 3:06 PM Dart.Guerin.Kimberley

**Certificat de Conformité / Certificate of Compliance**
(025311-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip
025311- 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
10-Jan-2020		Jigar Patel		POHB045517				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE105-42121W6-1 Rev.1	RBE105-42121W6 01-ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER ASTM B633 TYPE - 1, SC - 2 0.0003 "	ZINC CH	7	7	0	0	0
2	RBE117-68021W13-3 Rev.1	RBE117-68021W13 01-ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER ASTM B633 TYPE - 1, SC - 2 0.0003 "	ZINC CH	7	7	0	0	0

RECEIVED
JAN 14 2020
DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.